

Work Order ID 108990

108990

Page 1

October-31-13 1:09:45 PM

Item ID: D3065-041 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Step Leg Assembly
 Start Date: 10/31/13 Start Qty: 10.00 *10* Cust Item ID:
 Required Date: 11/14/13 Req'd Qty: 10.00 *10* Customer:
 Reference:

Approvals: Process Plan: MCS Date: 13-10-31 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3065	Rev B								
100		0.00							
100	Small Fab								
Small Fab	Memo	0.00							
Small Fab	Assemble as per Dwg D3065 and Identify as D3065-041								
110		0.00							
110	QC5- Inspect part completeness to step on W/O								
QC	Memo	0.00							
Quality Control									
120		0.00							
120	Identify as per dwg & Stock Location: <u>WVA.003</u>								
Packaging	Memo	0.00							
Packaging									

10x 13/10/31 DAS 36 9-89

10 13-11-01 DAS 19 9-89

10 13-11-01

Work Order ID 108990

October-31-13 1:09:45 PM

108990

Page 2

Item ID: D3065-041 Accept ***N900040100*** Setup Start ***NS1***
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Item Name: Step Leg Assembly
Start Date: 10/31/13 Start Qty: 10.00 ***10*** Cust Item ID:
Required Date: 11/14/13 Req'd Qty: 10.00 ***10*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC21- Final Inspection - Work Order Release	0.00							
130									
QC	Memo	0.00							
Quality Control									

Handwritten signature and date: 11/13-11-05
Handwritten text: MB-11-01

Picklist Print

October-31-13 1:09:49 PM

Page 1

Work Order ID: 108990

108990

Parent Item: D3065-041

D3065-041

Parent Item Name: Step Leg Assembly

Start Date: 10/31/13

Required Date: 11/14/13

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev: C02.11.01 Incorporated D3066-1 IPPKJ/RF

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3065-1		Manufactured	No			100	Each	116.0000	1	10			DAS 36 9-89

D3065-1

Step Spacer

Location Loc Qty Loc Code

GA 116
101780 80
102232 34
74497 1
81303 1

**

13/10/31

D3065-3 Manufactured No

100 Each 38.0000 1 10

D3065-3

Step Spacer

**

13/10/31

DAS
36
9-89

Location Loc Qty Loc Code

GA 38
102310 4
69827 1
73290 4
75152 14
83734 12
83873 1
95698 2

4

B101481
(64)

Picklist Print

October-31-13 1:09:49 PM

Page 2

Work Order ID: 108990

108990

Parent Item: D3065-041

D3065-041

Parent Item Name: Step Leg Assembly

Start Date: 10/31/13

Required Date: 11/14/13

Start Qty: 10.00

Required Qty: 10.00

D3065-5

Manufactured No

100

Each

142.0000

2

20

**

D3065-5

Step Leg

DAS
36
9-89

13/10/31

Location

Loc Qty

Loc Code

GA

142

101458

18

101655

61

103544

40

67222

1

73289

19

99340

3

20

D3065-7

Manufactured No

100

Each

111.0000

1

10

**

D3065-7

Step Spacer

DAS
36
9-89

12/10/31

Location

Loc Qty

Loc Code

GA

111

101512

60

102348

9

73291

7

74499

1

78666

4

83738

1

89971

10

91548

19

10

October-31-13 1:09:49 PM

Shop Packet Print

Page 2

Picklist Print

October-31-13 1:09:49 PM

Page 3

Work Order ID: 108990

108990

Parent Item: D3065-041

D3065-041

Parent Item Name: Step Leg Assembly

Start Date: 10/31/13

Required Date: 11/14/13

Start Qty: 10.00

Required Qty: 10.00

MS20470AD4-4

Purchased

No

100

Each

4,710.000

30

300

MS20470AD4-4

Rivet, Universal Head

**

13/10/31

DAS
36
95

Location

Loc Qty

Loc Code

GA

1

121652

1

ST336

4709

116188

68

118614

135

122027

188

m125807

702

m126275

3616

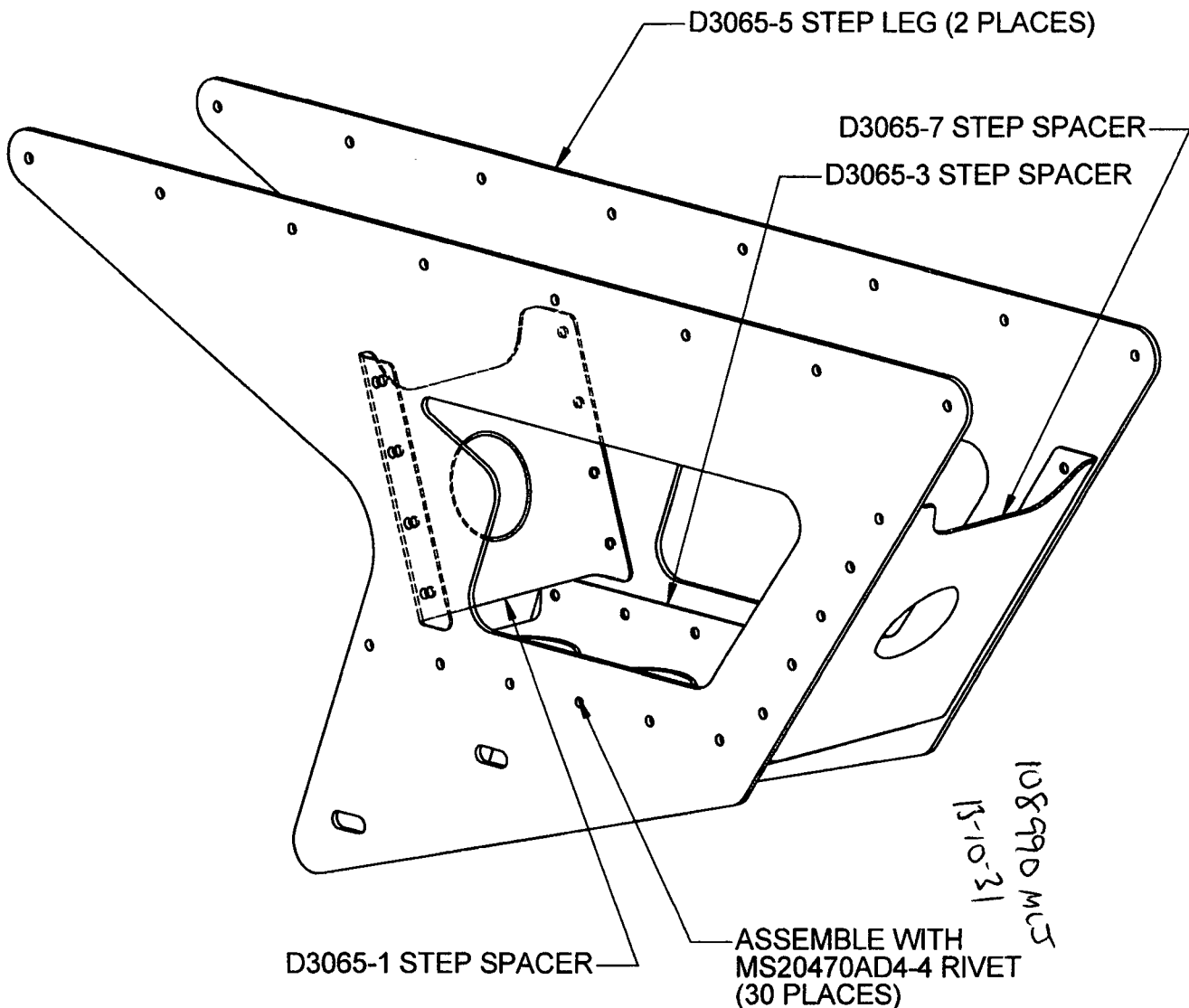
300



DESIGN <i>CP</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3065	REV. B SHEET 1 OF 5
DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SCALE 1:2
A	02.09.11	NEW ISSUE	
B	06.05.23	ADD 6061-T6 MATERIAL, ADD SLOTS TO D3065-5	

RELEASED

06.06.20 *[Signature]*



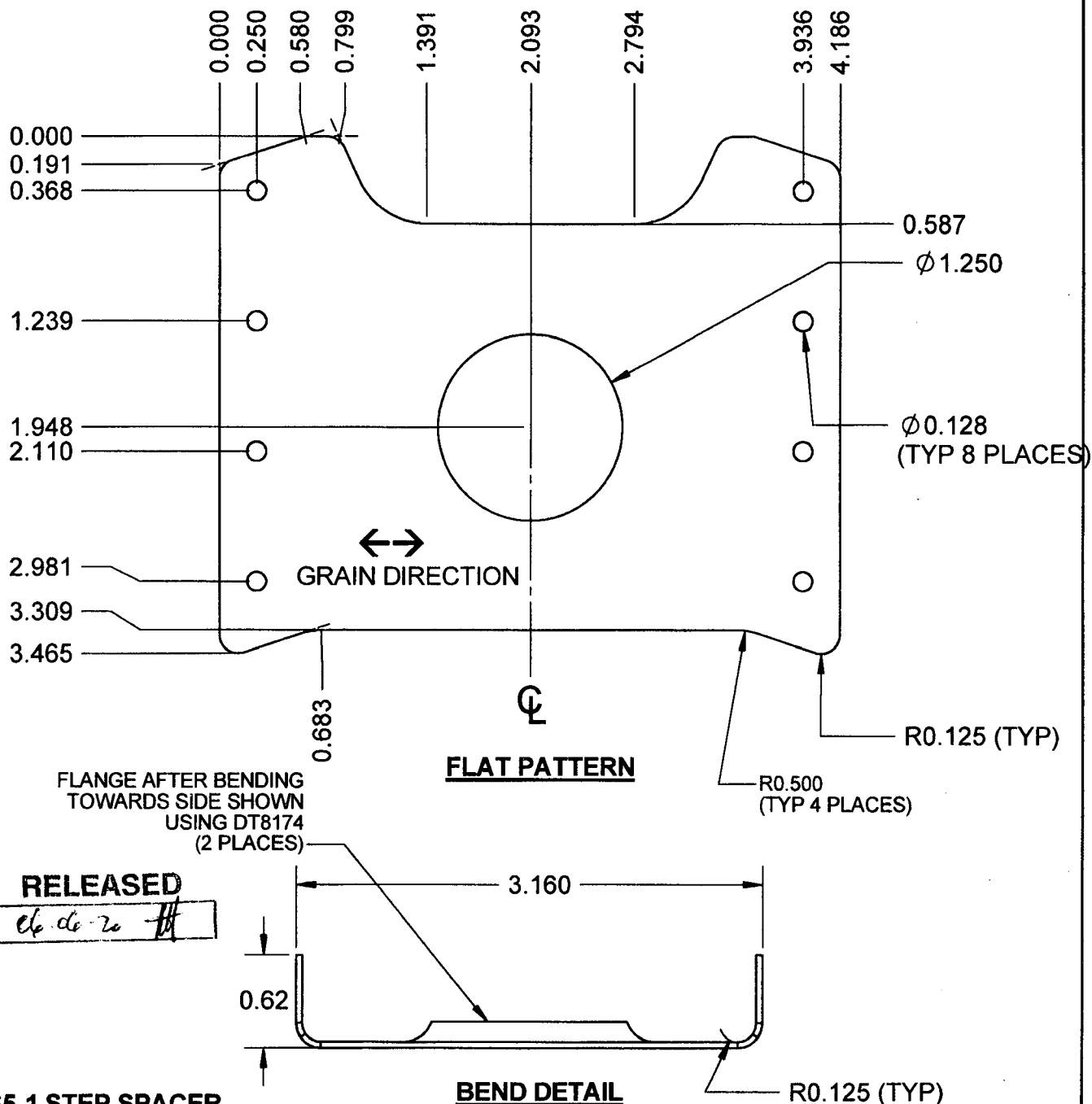
D3065-041 STEP LEG ASSEMBLY

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CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3065	REV. B SHEET 2 OF 5
DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SCALE 1:1



D3065-1 STEP SPACER

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

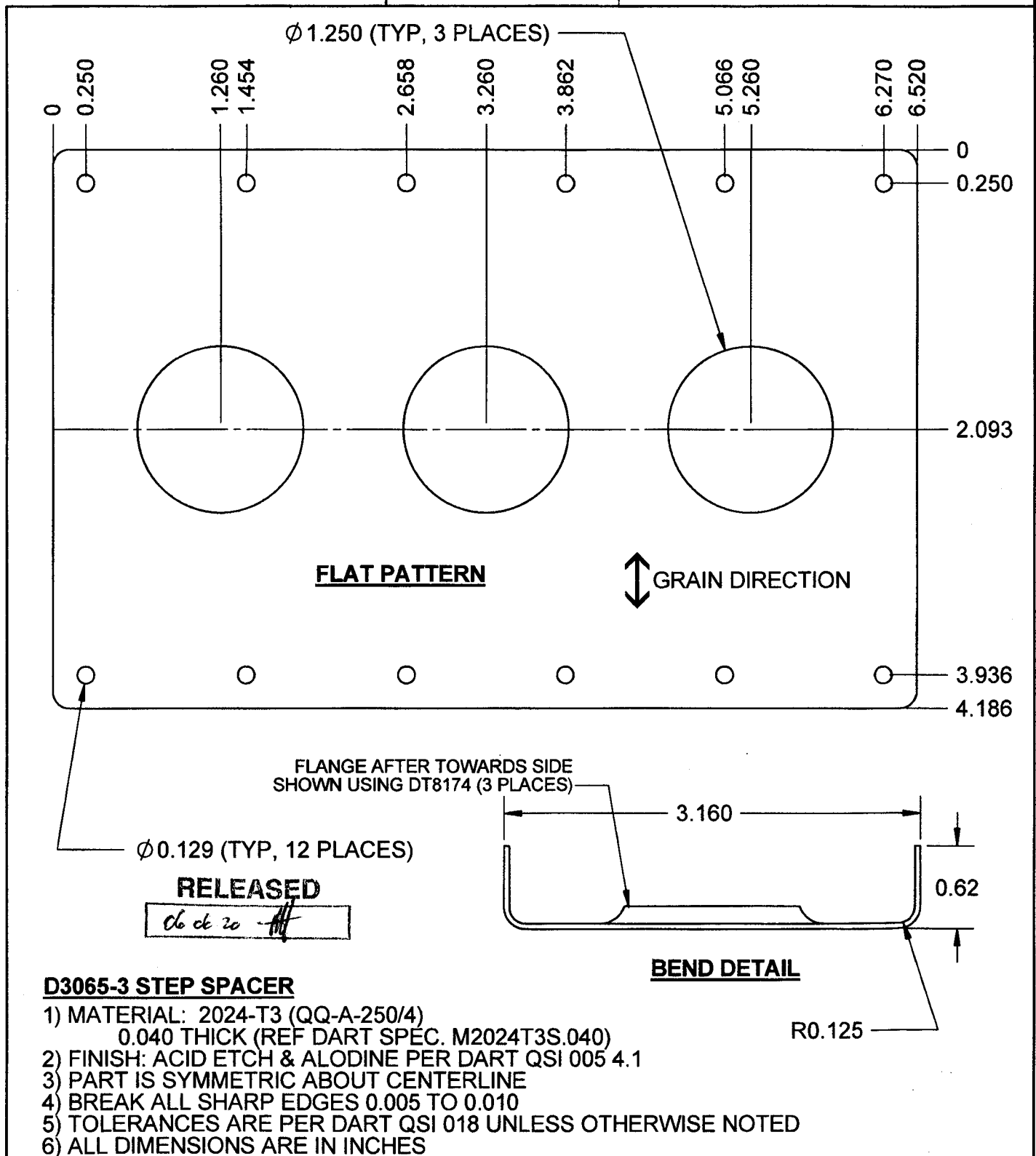
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108690



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CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3065	REV. B SHEET 3 OF 5
DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SCALE 1:1



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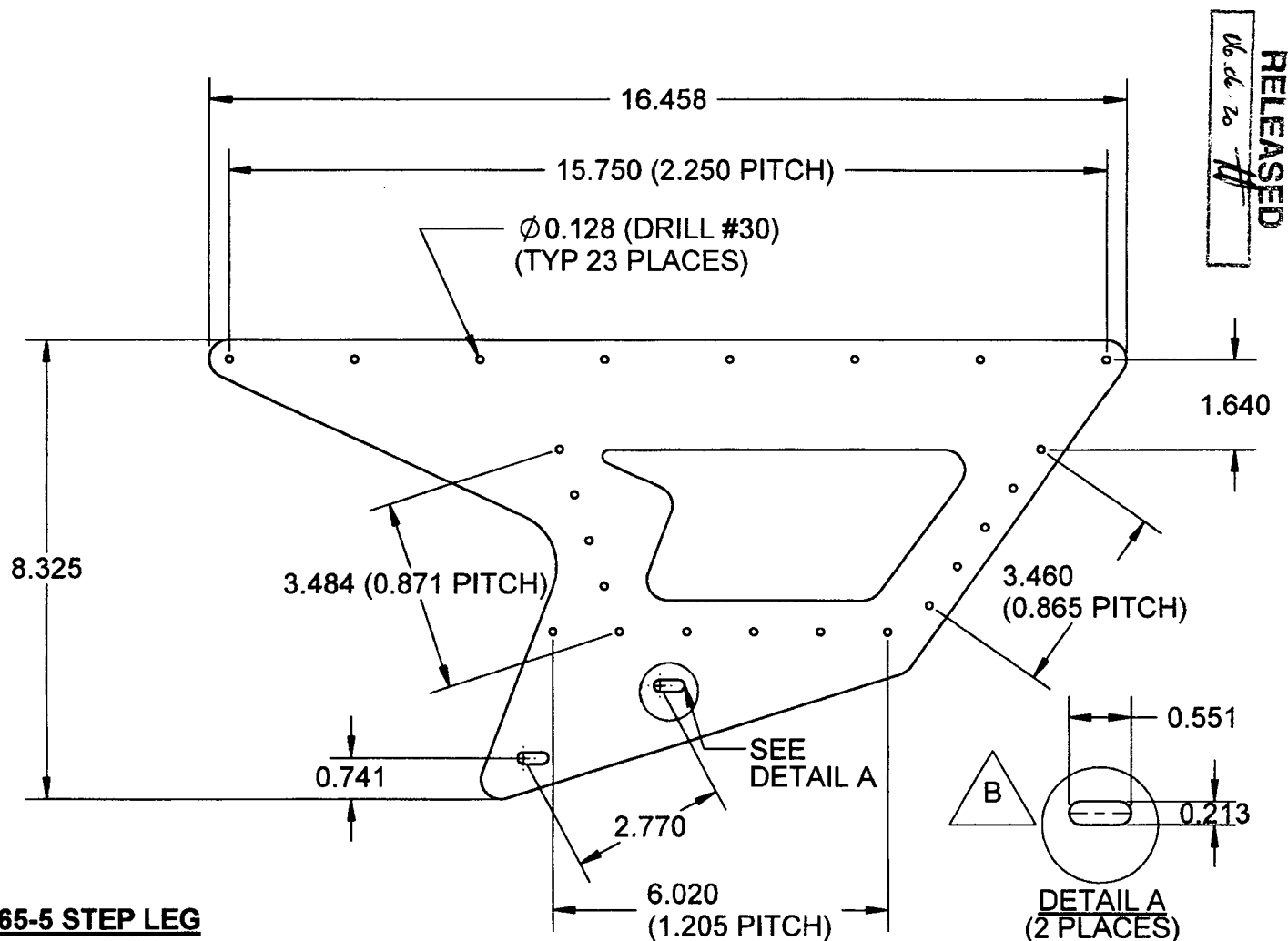
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065801

108990

DART

DESIGN	CP	DRAWN BY	CB	DART AEROSPACE LTD
CHECKED	PH	APPROVED	PH	HAWKESBURY, ONTARIO, CANADA
DATE	06.05.23	DRAWING NO.	D3065	REV. B
		TITLE	STEP LEG ASSEMBLY	SHEET 4 OF 5
		SCALE	1:3	

**D3065-5 STEP LEG**

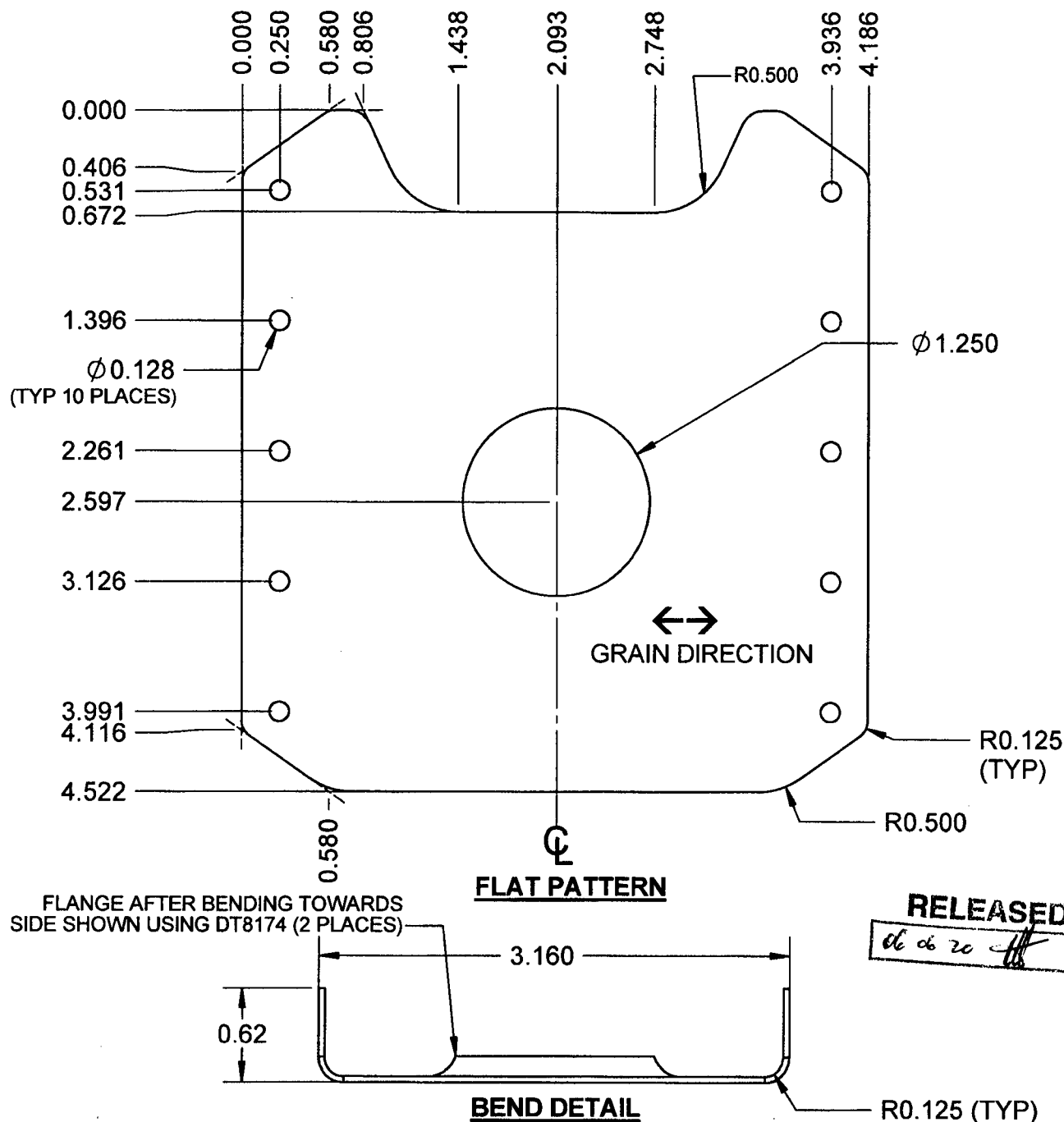
- 1) MACHINE PER DWG FILE "D3065-5.SLDPRT"
- 2) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK
(REF DART SPEC M6061T6S.080)
OR
5052-H32 (PER QQ-A-250/8 OR AMS 4016) 0.080 THICK (REF DART SPEC. M5052H32S.080)
- 3) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3065	REV. B SHEET 5 OF 5
DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SCALE 1:1

**RELEASED****D3065-7 STEP SPACER**

- 1) MATERIAL: 2024-T3 (PER QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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